

# Work Order ID 53922

November 23, 2009 2:50:11 PM

Page 1

Item ID: D2530

Accept

Revision ID: B

Item Name: Handle Weldment

Start Date: 23/11/2009 Start Qty: 10.00

Required Date: 02/12/2009 Req'd Qty: 10.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2530

Rev B

100

0.00



Small Fab

Small Fab

Memo

0.00

SAD 09-12-10

Small Fab

1-Cut to length as per Dwg D2536□2-Deburr

10

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

27 S 09/12/10

Quality Control

10

120

Large fab  
Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

1-Weld as per Dwg D2530 and QSI 004 using Welding Jig DT8301□2-Deburr

Large Fab

09/12/11

A/R SS. Rod Batch: 11/09213

10X

09/12/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 53922

November 23, 2009 2:50:11 PM



Page 2

Item ID:	D2530	Accept		Setup	Start	
Revision ID:	B				Stop	
Item Name:	Handle Weldment					
Start Date:	23/11/2009	Start Qty:	10.00	Cust Item ID:		
Required Date:	02/12/2009	Req'd Qty:	10.00	Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
QC Quality Control	Memo	0.00				PD	09.12.14	(10)	
140 	QC5- Inspect part completeness to step on W/O	0.00							
QC Quality Control	Memo	0.00				x10	/		
150 	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00							
Powdercoat Powder Coating	Memo START TIME: 2:45 3:20 FINISH TIME	0.00							
	OVEN TEMPERATURE: 3:15								
	BR 09-12-14								
	(10)								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 53922

November 23, 2009 2:50:11 PM



Page 3

Item ID: D2530	Accept		Setup	Start	
Revision ID: B				Stop	
Item Name: Handle Weldment					
Start Date: 23/11/2009	Start Qty: 10.00		Cust Item ID:		
Required Date: 02/12/2009	Req'd Qty: 10.00		Customer:		
Reference:					

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00 0.00	= 7 Mf 09/12/15			(X10)	0		
170  Packaging Packaging	Identify as per dwg & Stock Location: <u>506</u>  Memo	0.00 0.00	mb 09/12/15			X10			
180  QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00 0.00							

09/12/17 JG  
09/12/14  
(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

November 23, 2009 2:50:18 PM

Page 1

Work Order ID: 53922

Parent Item: D2530RevB

Parent Item Name: Handle Weldment

Comments:

Start Date: 23/11/2009

Required Date: 02/12/2009

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2534RevD Lock Plate		Manufactured	No			100	Each	29.0000	20.0000			

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 29

52569 29

M304TR0.750W.049

Purchased

No

120

f

357.6711

30.6789



304 RD Tube .750 x .049W

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT 357.6711

107518 2.77

108498 0

109314 8.5

110113 0.73

110271 0.03

111096 9

111457 11.43

112652 85.89

112800 239.3211

*epc 09/12/11*

*10*

*SAD 09-12-10*

30.6789

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**DART**

DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	PH	DRAWING NO.	REV. B
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	D2530	SHEET 1 OF 1
DATE	TITLE		SCALE
04.12.14	HANDLE WELDMENT		
A	96.06.18	NEW ISSUE	
B	04.12.14	UPDATE NOTES AND DIMENSIONS	

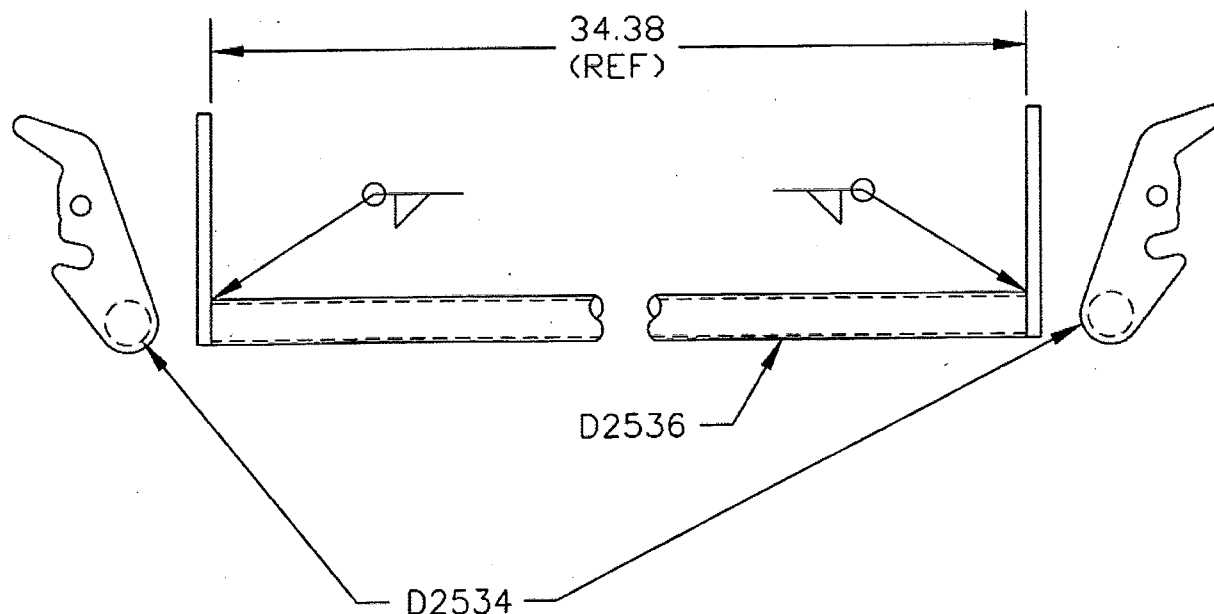
RELEASED

04.12.16 *[Signature]*

## PART LIST -- D2530

QTY	PART NUMBER	DESCRIPTION
-X	D2530	HANDLE WELDMENT
1	D2536	HANDLE
2	D2534	LOCK PLATE

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER NO. *53922*

**D2530 HANDLE WELDMENT**

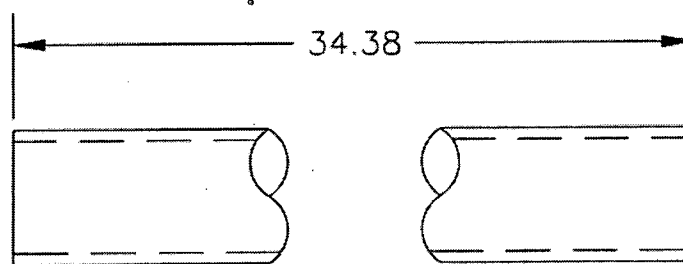
- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**DART**

DESIGN	DRAWN BY	DART AEROSPACE LTD	
B WILLIAMS	PH	VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2536	REV. B SHEET 1 OF 1
DATE 04.12.14	TITLE HANDLE		SCALE NTS
A	96.05.15	NEW ISSUE	
B	04.12.14	UPDATE NOTES	

**RELEASED**

04.12.16 #

**REFERENCE ONLY****D2536 HANDLE**

- 1) MATERIAL: AISI 304/316 SS  $\phi 0.75$  X 0.049 WALL (REF. DART SPEC. M304TR0.750W.049)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED